

Work Order ID 144904

April 27, 2016 11:26:42 AM

U/R

144904

Beel order May 10.
Special Parts to pull.

Page 1

Item ID: D412-698-023

Accept

N900040100

Setup Start ***NS1***

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Stop ***NS2***

Start Date: 5/4/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 4.00

4

Customer: CBELL02

Reference:

Approvals:

Process Plan: *SH*

Date: *20160427*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E U/R	<i>OK with change on D3594-043/-044</i>	<i>Q1614127</i>					<i>MHJ</i>	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023		CHG002						
						<i>4</i>	DAS 28 9-89		MAY 09 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
						<i>4</i>	DAS 28 9-89		MAY 08 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.12							
Quality Control									
						<i>4</i>	DAS 28 9-89		MAY 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Work Order ID 144904

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144904

Page 2

Item ID: D412-698-023

Accept

N900040100

Setup

Start

NS1

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Stop

NS2

Start Date: 5/4/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 4.00

4

Customer: CBELL02

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP D412-698-023
Location:FG022*Handwritten signature**4X*DAS
28
9-00

MAY 09 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.40

Memo

MLS

MAY 10 2016

MAY 10 2016

MLS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

April 27, 2016 11:26:46 AM

Page 1

Work Order ID: 144904

144904

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/4/2016

Required Date: 5/10/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-11		Manufactured	No			120	Each	14.0000	1	4			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3552-11

Door Prop

DAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
----	---	--

128491	2	
--------	---	--

80345	2	
-------	---	--

ST363	10	
-------	----	--

142260	10	
--------	----	--

D3594-043		Manufactured	No			120	Each	10.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3594-043

Floor Doubler Assembly, LH

Only pull 144905 for this

Location	Loc Qty	Loc Code
----------	---------	----------

ST504	10	
-------	----	--

130499	10	
--------	----	--

D3594-044		Manufactured	No			120	Each	14.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3594-044

Floor Doubler Assembly, RH

Only pul 144906 for this

Location	Loc Qty	Loc Code
----------	---------	----------

ST504	14	
-------	----	--

130500	14	
--------	----	--

D3594-5		Manufactured	No			120	Each	4.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3594-5

Doubler

Location	Loc Qty	Loc Code
----------	---------	----------

ST044	4	
-------	---	--

130501	4	
--------	---	--

DAS
27
9-89

DAS
27
9-89

MAY 08 2016-89

DAS
27
9-89

MAY 08 2016-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

Special for Bell 412 EPI

4

144905

144906

4

Picklist Print

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Page 2

Work Order ID: 144904

144904

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 5/4/2016

Required Date: 5/10/2016

Start Qty: 4.00

Required Qty: 4.00

D3622-1 Manufactured No

120 Each 12.0000 2 8

D3622-1

Ball Stud

DAS
28
9-89

**

Location

Loc Qty

Loc Code

ST046

12

131624

12

MS20426AD4-4

Purchased No

120 Each 4,755.000 2 8

MS20426AD4-4

Rivet

DAS
28
9-89

**

Location

Loc Qty

Loc Code

GA

2078

125445

2078

ST312

2677

m132536

2677

MS21073L5

Purchased No

120 Each 20.0000 1 4

MS21073L5

Anchor Nut

DAS
28
9-89

**

Location

Loc Qty

Loc Code

ST298

20

m132680

20

NAS1149D0516J

Purchased No

120 Each 159.0000 2 8

NAS1149D0516J

Washer

DAS
28
9-89

**

Location

Loc Qty

Loc Code

ST264

159

M129706

159

April 27, 2016 11:26:46 AM

Shop Packet Print

Page 2

Under Review Notification

Raised By: M. BELLAVANCE

Product #: D412-698-023

Date: 16.02.25

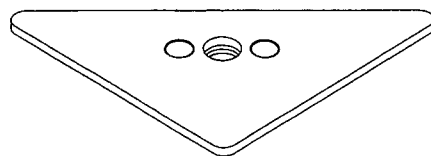
Product Name: AUTOMATIC DOOR OPENER KIT

Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3594-043/-044/-3/-4	D3594 Rev. B	N	Y	N	Y	N	Y	N	16-531	See below.
D412-698-023	IIN-D412-698 Rev. E	N	Y	N	Y	N	Y	N	16-531	See below.

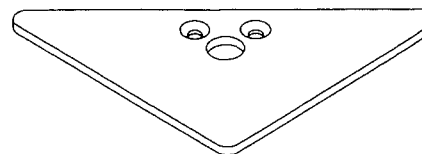
Description of Issue:

Current stock OK to ship to customers other than Bell Helicopter Mirabel.

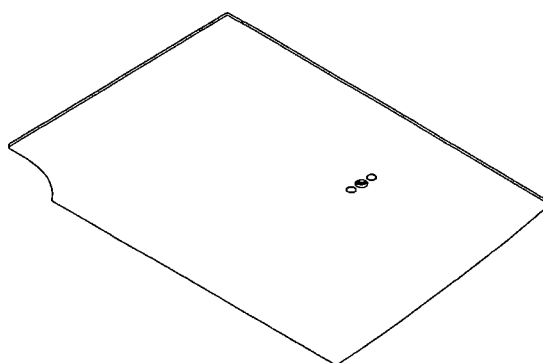
If shipping to Bell Helicopter Mirabel: must ship D412-698-023 with enlarged D3594-043/-044/-3/-4. Eng. To sign off deviations on W/Os.
Change: addition of material, 0.25", on the inboard and outboard edges as shown to facilitate installation with existing equipment.



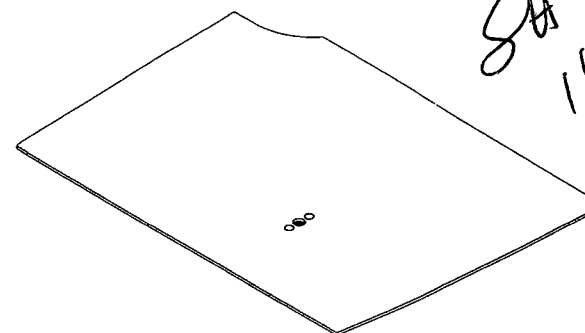
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



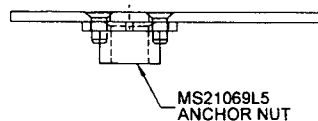
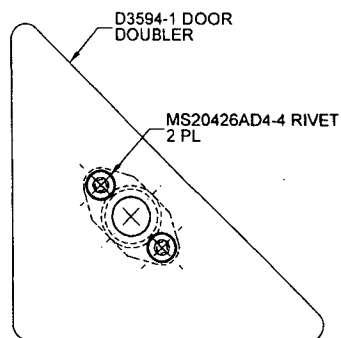
D3594-044 FLOOR DOUBLER ASSEMBLY

20160429
SA
144904

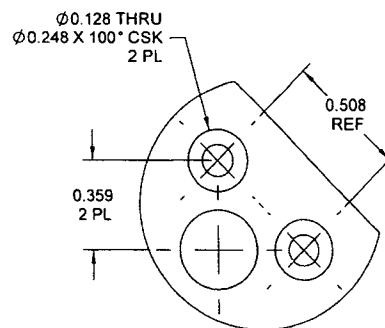
RELEASED
080514

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

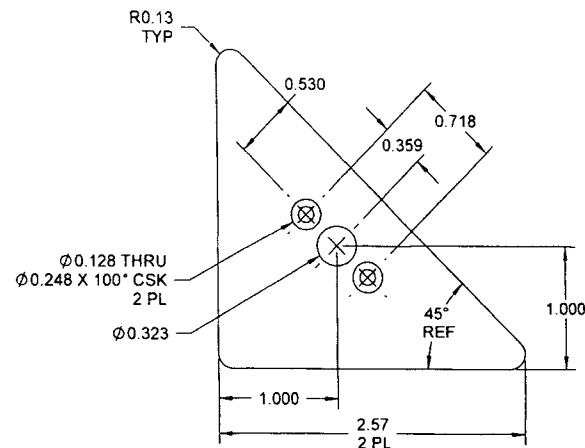
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



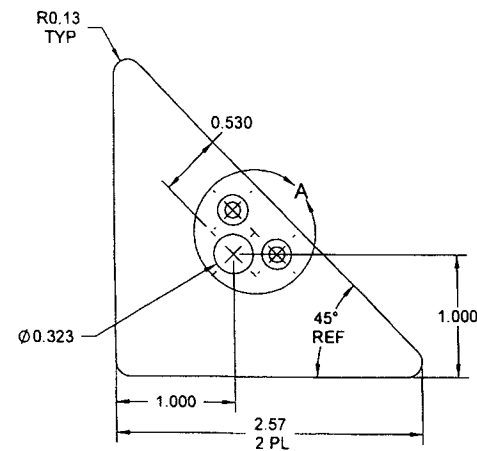
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

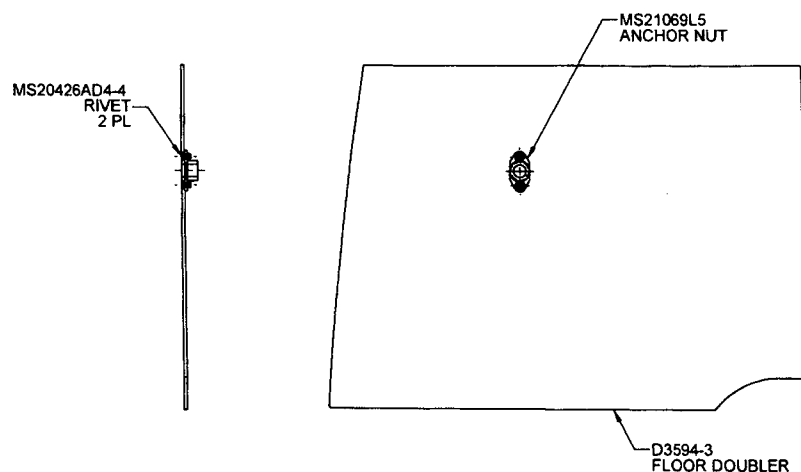
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

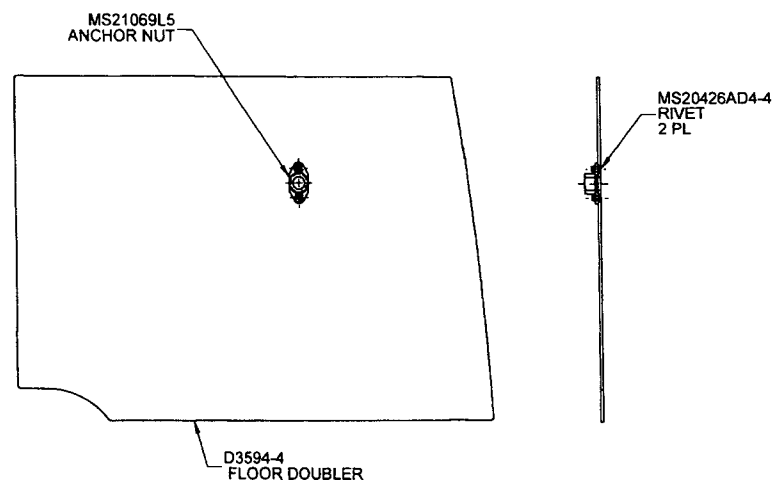
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
08-06-26-14

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



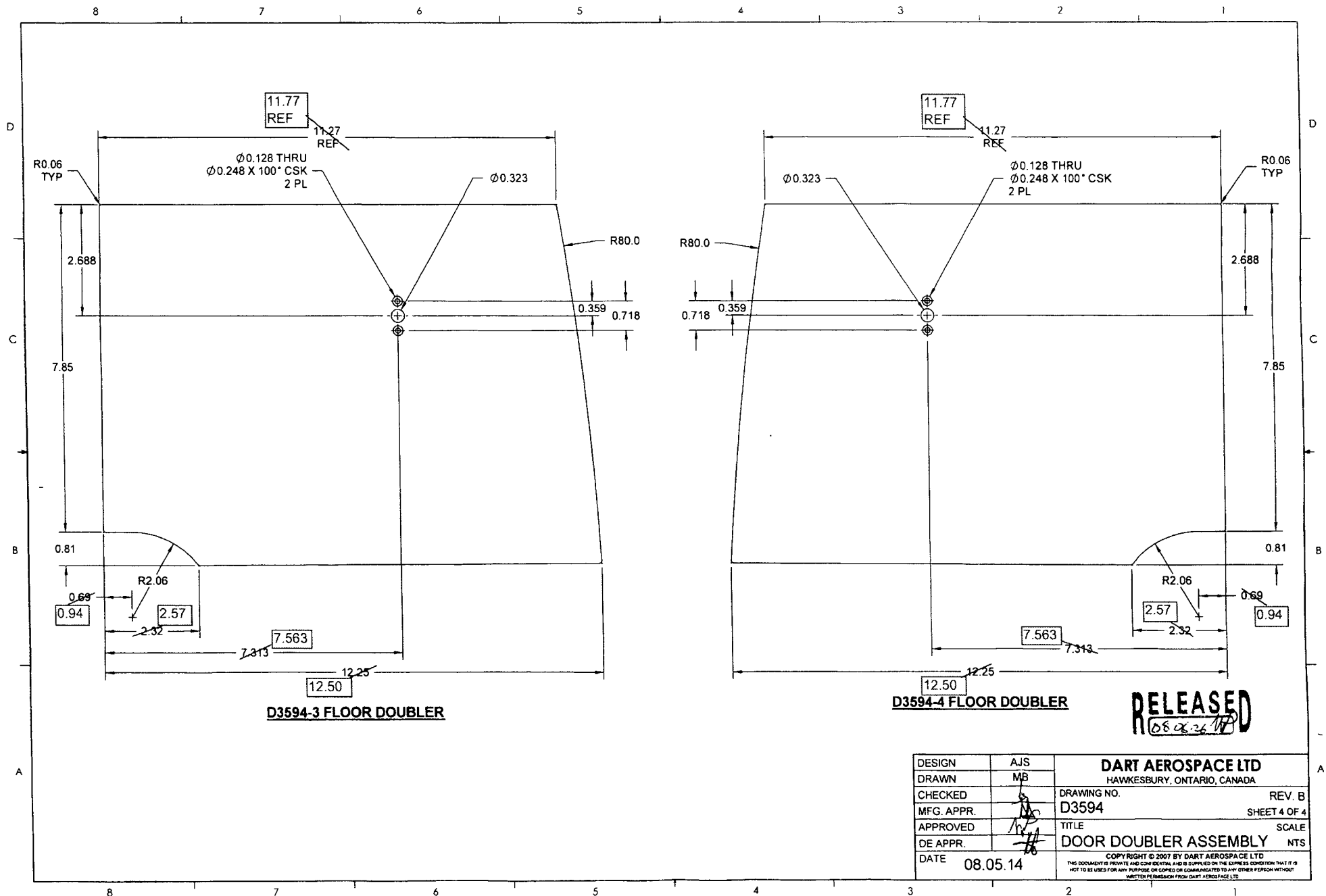
D3594-044 FLOOR DOUBLER ASSEMBLY

RELEASED
108-06-26-14

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE DOUBLER	SCALE
DE APPR.			NTS
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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

REFERENCE ONLY

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

DAS
28
9-89

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Revision: E

Date: 08.05.01